

Work Order ID 120676

June-10-14 10:46:27 AM

Handwritten: **POST #1 URGENT!**
120676

Page 1

Item ID: 646.3315

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade

Start Date: 6/10/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/18/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3300

N/C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 2.600"

Handwritten: **OK 14/06/12 20**

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB147

DWG REV: *N/C*

FOLIO REV: *AA*

Handwritten: **OK 14/06/12 20**

DAS

14

9-89

2- deburr and break all sharp edges except otherwise noted

Work Order ID 120676

120676

Page 2

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

am 14/06/12

20

0

DAS
14
9-89

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

20

0

DAS
44
9-89 14/06/13

Quality Control

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

0.00

CL 14/06/17 20

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 24623

Work Order ID 120676

June-10-14 10:46:27 AM

120676

Page 4

Item ID: 646.3315

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

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Item Name: Blade

Start Date: 6/10/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/18/14

Req'd Qty: 20.00

20

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC14- Inspect Spray Paint

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

MF

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

(20)

20X

DAS
28
9-89

JUL 02 2014

14/7/3

MF
M-7-02

Picklist Print

June-10-14 10:46:27 AM

Page 1

Work Order ID: 120676

120676

Parent Item: 646.3315

646 3315

Parent Item Name: Blade

Start Date: 6/10/14

Required Date: 6/18/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	169.8430	0.217	5			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

Loc Qty

Loc Code

MAT006

169.843

M126438

120

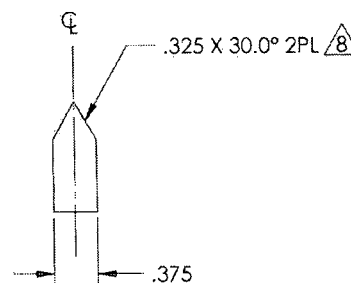
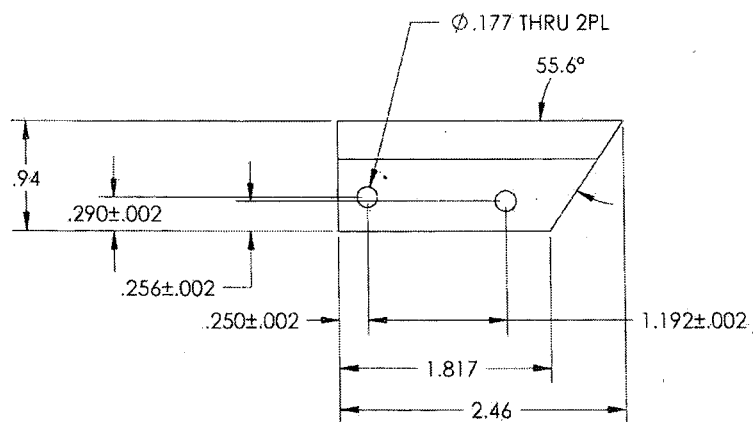
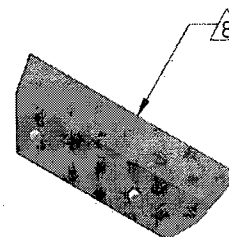
→ M127494

49.843

5 on 14/05/12

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REV.	DESCRIPTION	DATE	APPROVED



W/6120676

646.3315

OFFICIAL DATE MAY 04 1998		APICAL INDUSTRIES	
DESIGNED BY L. HOFF	CHECKED BY P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .1°		MATERIAL CODE B 07M16	REV. N/C
SCALE NONE		DWG. NO. 646.3300	SHEET 7 OF 8



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24623**

Purchase Order Date 6/17/2014

PO Print Date 6/17/2014

Page Number 1 of 2

Order From :

VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	120676	646.3315 BLADE	7/3/2014 Yes 7/3/2014		20.00 ✓	\$0.00	\$0.00
	FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS						
	PART ARE MADE FROM AISI A2 TOOL STEEL						
	PLEASE NOTE: DETAIL C OF C REQUIRED						
	Line Total:						\$0.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	7/3/2014 No 7/3/2014		1.00 ✓	\$0.00	\$0.00
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A020 non-destructive test/inspection identification A021 dart aerospace processing A024 process certifications A026 certification of material conformance						

Note:

6/17/2014

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDIT Shipper
196636	1	82292

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON. K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON. K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
24623		A2	2014/6/18	FEDEX

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
20	646.3315	(20) 646.3315 BLADE REF. 120676		3,3

1 BOITE DE CARON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
-------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 20

POIDS EXPÉDIÉ / Weight Shipped : 3,30

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 20

POIDS EXPÉDIÉ / Weight Shipped : 3,30

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
196636	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
24623		A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	59 - 61 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
20	3.3	646.3315 (20) 646.3315 BLADE REF. 120676 1 BOITE DE CARON

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 PREHEAT 1	1200	0:30	VAC			390				
4.00 PREHEAT 2	1500	0:30	VAC			390				
5.00 VAC HARDE	1800	1 hrs 30 minutes	VAC		AZOTE	390				
6.00 TEMPER	400+/-10°F	2 hrs	air			651				
7.00 TEMPER 2	400+/-10°F	2 hrs	air			651				

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

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CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
8.00 HARDN INS										
9.00 FINAL INSP										06-20-2014

COMMENTAIRES / comments

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

Unik Cordier

18

DATE: 2014-06-21

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client./We certify that all the information on this report is exact and in accordance with the order requirements.